

Work Order ID 71659

Thursday, July 07, 2011 12:07:30 PM



Page 1

Item ID: D2565-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/07/07 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2565 | Rev E | | | | | | | | |

100 Punch ends and deburr as per dwg 0.00
 NC BRAKE
 Brake NC Memo 0.00
 Brake NC Punch as per Dwg D2565 using DT 8313

SO 1169/13

(6)

110 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab Drill hole open to .316 Ø as per Dwg D2565 (one end only)
 Deburr

4/10/04 (6)

120 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

8/11/05

(x6)

| W/O: <u>71659</u> | | WORK ORDER CHANGES | | | | | |
|-------------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2565-101 PAR #: _____ Fault Category: Small PAB / ~~manuf~~ ^{manufacturer} NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------------|------------|--|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|----------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>u/10/05</u> | <u>#16</u> | <u>Found at inspection of y x1</u> <u>Strut with a small indentation</u> <u>on it.</u> <u>R-4 mat has marks / pings</u> | | <u>u/10/05</u> | | | | <u>S</u> <u>u/10/06</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45
400 OF
8:15

0.00

6XØ m-11/10/06

Powder Coating

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 of 11/10/06
counted & measured

150

Identify as per dwg & Stock Location: SC270 0.00



Packaging

Memo

0.00

Packaging

6XØ 8P11-10-7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 11-10-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:07:28 PM

Page 1

Work Order ID: 71659

Parent Item: D2565-101

Parent Item Name: Strut



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: F02.04.16 Added dwg Rev.C1 NG

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TR0.750W.049 | | Purchased | No | | | 100 | f | 238.7586 | 1.71 | 10.8 | | | |



304 RD Tube .750 x .049W



SB 11/09/13

Location

Loc Qty

Loc Code

MAT017

238.75863

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117030

3.09263

117797

0.75

117983

200

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

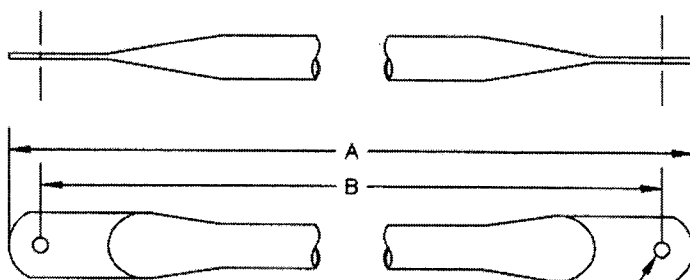
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------|----------|--|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2565 | REV. E SHEET 1 OF 1 |
| DATE 04.05.05 | | TITLE STRUT SCALE 1:3 | |
| A | 96.05.03 | NEW ISSUE | |
| B | 97.03.15 | CORRECT D2565-111 DIM. A | |
| C | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603) | |
| D | 02.06.05 | ADD -3XX PARTS; ADD FINISH | |
| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | |

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71659

| PART # | A | B | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | - |
| D2565-109 | 12.31 | 11.51 | - |
| D2565-111 | 13.65 | 12.85 | - |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | - |
| D2565-209 | 15.16 | 14.36 | - |
| D2565-211 | 14.14 | 13.34 | - |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | - |
| D2565-309 | 20.17 | 19.37 | - |
| D2565-311 | 16.30 | 15.50 | - |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | - |
| D2565-409 | 9.34 | 8.54 | - |
| D2565-411 | 13.81 | 13.01 | - |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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